

Date: Friday, 12/9/2005 10:04:24 AM
 User: Linda Lacelle

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BASKET MOD KIT |
| Job Number : 25180 | |
| Estimate Number : 11337 | |
| P.O. Number : N/A | Part Number : DSI9268011 |
| This Issue : 12/9/2005 S.O. No. : N/A | Drawing Number : D3230 REV A1 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : LARGE FAB ASSY | Drawing Revision : A1 |
| Previous Run : N/A | Material : N/A |
| Written By : <u>See comment below</u> | Due Date : 12/16/2005 Qty: 2 Um: Each |
| Checked & Approved By : <u>See comment below</u> | |
| Comment : Est Rev:B 03.11.19 Kit redesign KJ/DS | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TS0750W065 | 304 SQ Tube.75x.75x.065W |
|-----|----------------|--------------------------|



Comment: Qty.: 25.8300 f(s)/Unit Total : 51.6600 f(s)
 Material: 304/316 SS Tube 0.065" wall
 (M304TS0.750W.065)
 Batch: M18796

AD05/12/20

| | | |
|-----|--------|----------------|
| 2.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2327-3 Spacer Bushing B24530

AD05/12/20

| | | |
|-----|--------------|--------------------------|
| 3.0 | M304EX07516F | Expanded Metal Flat Stai |
|-----|--------------|--------------------------|



Comment: Qty.: 5.2500 sf(s)/Unit Total : 10.5000 sf(s)
 Pick:
 Qty Part Number Description Batch
 5sf M304EX0.75-16F Mesh M18480

AD05/12/20

| | | |
|-----|-------------|------------------------------|
| 4.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230


2-Fabricate basket wedge assembly as per D3230

A/R SS ROD Batch: M19174

2-Deburr & Remove all Markings From Material

AD05/12/20

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--|----|------|-----|---|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 05.12.20 | 4. | CHANGE 16.00" Dimension on dwg D3230 Rev-A1 to 15.75" for drilling of ϕ 0.266 holes | | | |  05.12.20 per Q51042 | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 05/12/21
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 12/9/2005 10:04:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 25180

Part Number: DSI9268011

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------|-----------------|
| 5.0 | QC5/9 | WELD INSPECTION |
|-----|-------|-----------------|



Comment: WELD INSPECTION

PD 05-12-20

| | | |
|-----|----------------|----------------|
| 6.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 05 12 20 2

| | | |
|-----|-----|---|
| 7.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ML 05/12/20 2

| | | |
|-----|-------------|-----------------------|
| 8.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|--------|------|
| 9.0 | AN417A | Bolt |
|-----|--------|------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 5 | AN4-17A | Bolt | M15432 |

| | | |
|------|------------|--------|
| 10.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 5 | AN960JD416 | Washer | M18136 |

| | | |
|------|-----------|-----|
| 11.0 | MS21042L4 | Nut |
|------|-----------|-----|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 5 | MS21042L4 | Nut (or -4) | M17997 |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 12/9/2005 10:04:24 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET MOD KIT

Job Number: 25180

Part Number: DSI9268011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

DSI 9053011

Basket Hinge Change Kit



Qty 508

Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 DSI 9053-011 Hinge Change Kit B22955

C205112121 (2)

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

u

05-12-21 (2)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Dsi 9268-011

Location: _____

PPP Rev: A

C205112121 2

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

1 D205112121

Job Completion



u 05-12-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. DSI 9268 | REV. B SHEET 1 OF 2 |
| DATE 03.11.19 | | TITLE BASKET MODIFICATION KIT SCALE NTS | |
| A | 03.10.24 | NEW ISSUE | |
| B | 03.11.19 | CHANGE ORIENTATION OF WEDGE | |

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. E

REF. CANADIAN STC: SH96-120

REF. FAA STC: SR00696NY

THE PURPOSE OF THE DSI 9268-011 BASKET MODIFICATION KIT IS TO INCREASE THE VOLUME OF THE D205-541-043/-044 BASKETS. NOTE THAT D205-541-041 BASKETS MUST BE CONVERTED INTO D205-541-043/-044 PER DSI 9226 BEFORE PERFORMING THIS MODIFICATION.

TO INSTALL THE DSI 9268-011 KIT:

- 1) SEPARATE LID FROM BASE. FOR BASKETS WITH PIANO HINGES, REMOVE D2569 HINGE AND PLUG HOLES WITH RIVETS. INSTALL DSI 9052-011 HINGE CHANGE KIT, EXCEPT INSTALL D2332-3 ON D3230-041 BASKET WEDGE ASSEMBLY INSTEAD OF ON BASKET BASE. FOR BASKETS WITH DSI 9052-011 HINGE CHANGE KIT ALREADY INSTALLED, MOVE D2332-3 TO D3230-041 BASKET WEDGE ASSEMBLY. FOR BASKETS WITH HINGE PLATES WELDED TO LID & BASE, SIMPLY INSTALL D2232-3 ON D3230-041 BASKET WEDGE ASSEMBLY, OMITTING THE EXTRA WASHERS BETWEEN THE D2332-3 HINGE PLATE & D3230-041.
- 2) ATTACH LID TO D3230-041 BASKET WEDGE ASSEMBLY. MOVE D2332-041 PROP ASSEMBLY FROM BASKET BASE TO WEDGE ASSEMBLY PER FIGURE 1.
- 3) LOCATE D3230-041 BASKET WEDGE ASSEMBLY COMPLETE WITH BASKET LID ON THE EXISTING BASKET BASE. TEMPORARILY CLAMP IN PLACE AND CHECK FOR PROPER LATCHING OF THE EXISTING LID WITH THE WEDGE. ADJUST LOCATION OF WEDGE ASSEMBLY TO ENSURE PROPER LATCHING. SHIM AS REQUIRED TO ENSURE PROPER LATCHING.
- 4) TRANSFER LOCATION OF 1/4" ATTACHMENT HOLES FROM WEDGE TO EXISTING BASE.
- 5) REMOVE WEDGE AND DRILL Ø0.266" HOLES THROUGH THE EXISTING BASE. DEBURR HOLES.
- 6) INSTALL WEDGE USING AN4-17A BOLTS, AN960JD416 WASHERS, AND MS21042L4 NUTS PROVIDED (5 PLACES TOTAL). NOTE THAT THE BOLTS IN SOME LOCATIONS MAY HAVE TO BE INSTALLED WITH THE NUTS ON TOP BECAUSE OF CLEARANCE ISSUES.
- 7) ADJUST WEIGHT AND BALANCE AS FOLLOWS:

| Installation | Weight | Lateral | | Longitudinal | |
|-------------------------|--------|------------|--------------|--------------|------------|
| | | Arm | Moment | Arm | Moment |
| DSI 9268-011 | 20 lb | ± 63.13 in | ± 1263 in-lb | 132.25 in | 2645 in-lb |
| Basket Modification Kit | 9 kg | ± 1.60 m | ± 14.4 m-kG | 3.36 m | 30 m-kG |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 03.10.24
CERT. NO.: SH96-120
ISSUE NO.: 2

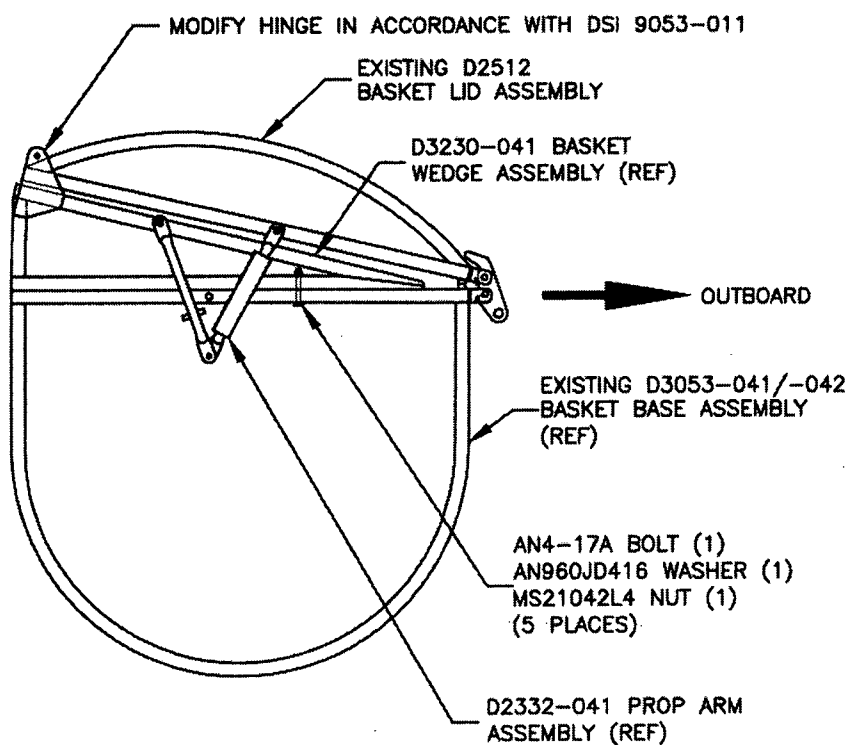
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. DSI 9268 | REV. B SHEET 2 OF 2 |
| DATE 03.11.19 | | TITLE BASKET MODIFICATION KIT | SCALE NTS |

| QTY -011 | P/N | DESCRIPTION |
|-------------|--------------|-------------------------|
| X | DSI 9268-011 | BASKET MODIFICATION KIT |
| 1 | D3230-041 | BASKET WEDGE ASSEMBLY |
| 1 | DSI 9053-011 | HINGE CHANGE KIT |
| 5 | AN4-17A | BOLT |
| 5 | AN960JD416 | WASHER |
| 5 | MS21042L4 | NUT |

**FIGURE 1**

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 03.10.24
CERT. NO.: SH96-120
ISSUE NO.: 2

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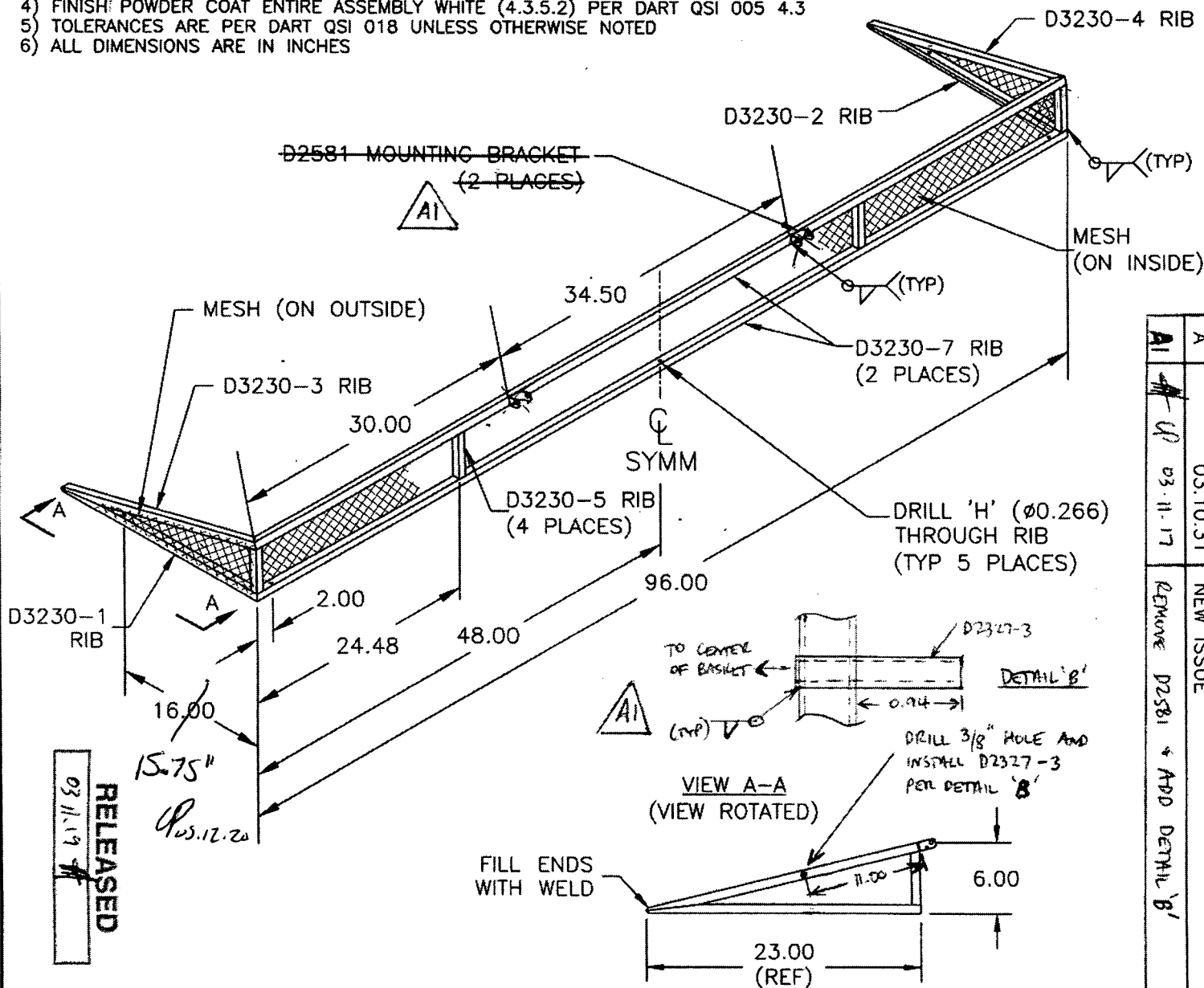
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| DATE | | TITLE | SHEET 1 OF 2 | SCALE |
| 03.10.31 | | BASKET WEDGE ASSEMBLY | | NTS |
| A | 03.10.31 | NEW ISSUE | | |
| A1 | 03.11.17 | REMOVE D2581 + ADD DETAIL 'B' | | |

D3230-041 BASKET WEDGE ASSEMBLY

- 1) RIB MATERIAL: AISI 304/316 SS, 3/4x3/4x0.060 WALL, SQUARE TUBING
(REF DART SPEC. M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC. M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

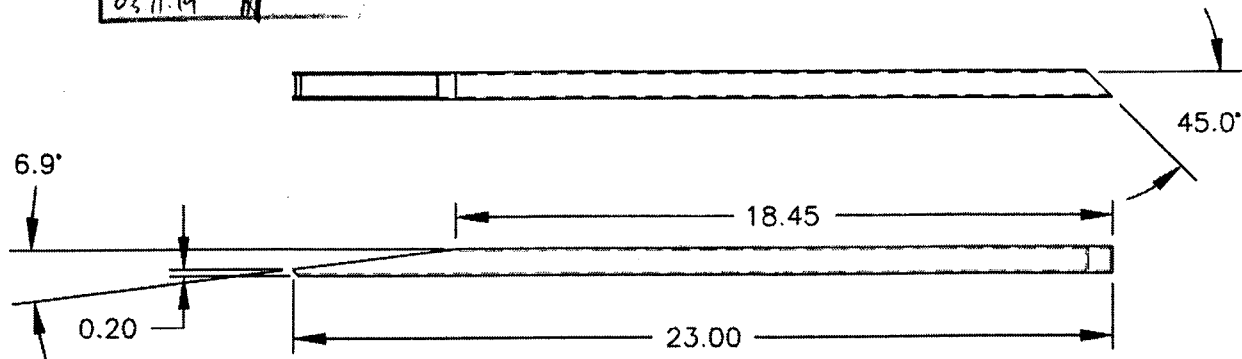
03.11.17



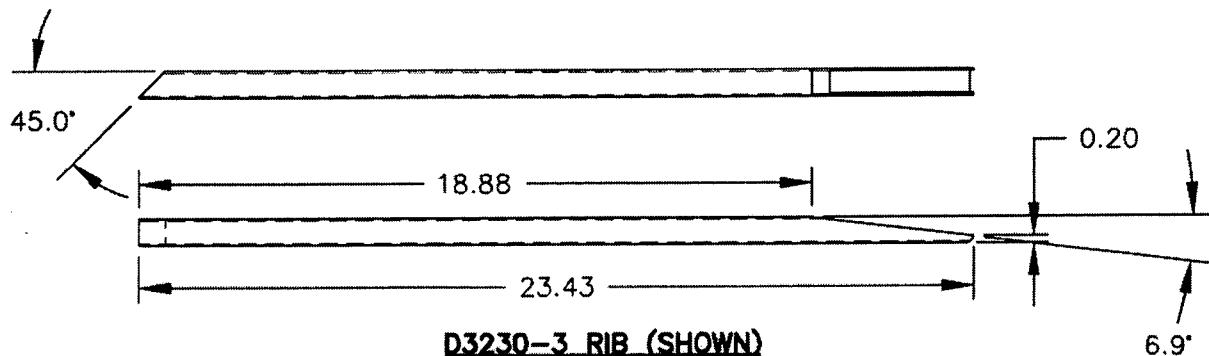
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3230 | REV. A SHEET 2 OF 2 |
| DATE 03.10.31 | | TITLE BASKET WEDGE ASSEMBLY | SCALE 1:5 |

RELEASED

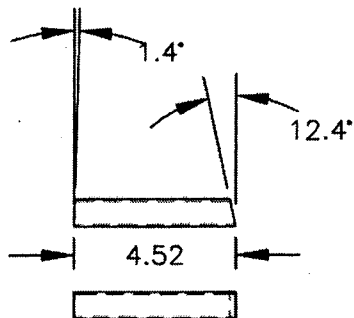
03.11.19 *[Signature]*



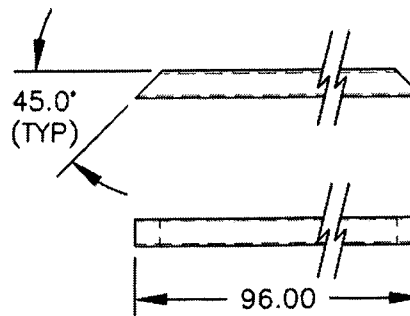
D3230-1 RIB (SHOWN)
D3230-2 RIB (OPPOSITE)



D3230-3 RIB (SHOWN)
D3230-4 RIB (OPPOSITE)



D3230-5 RIB



D3230-7 RIB

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Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: December 20, 2005 1:03 PM
To: Chris Provencal
Subject: Re: wedge for 212 basket

15.75" is an acceptable deviation on 16.00".
If it is going to cause a problem in the future, then I agree, you should make this a permanent change by doing an A2 revision to the drawing.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, December 20, 2005 8:43 AM
Subject: wedge for 212 basket

>
> D3230 Rev A1: David D. drilled the 0.266 diam hole at 15.75" instead of
> 16.00". This was because the gap for the nut was too small at 16". At
> 15.75" the gap is just over 0.5" and it needs to be 0.407".
>
> I think this should become a permanent change. When they weld the wedge,
> there can be some variation in the shape and this could happen again and
> it
> may not be caught.
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email..cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>